DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-022555
Date Inspected: 03-Apr-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	Mr. ZHU ZHONG HAI			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Segment

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna Pillai was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Trial Assembly Area:

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the deck panel diaphragm to deck panel diaphragm weld joint located on 13AW at counter weight side, Panel Point (PP-120). The weld is designated as SEG3013B-254. The welder is identified as 048696. ZPMC QC Mr. SHEN JIAN BO was onsite monitoring the welding variables. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2233-ESAB. Further weld detail mention in attached picture.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the deck panel diaphragm to deck panel diaphragm weld joint located on 13AW at cross beam side, Panel Point (PP-120). The weld is designated as SEG3013C-142. The welder is identified as 048433. ZPMC QC Mr. SHEN

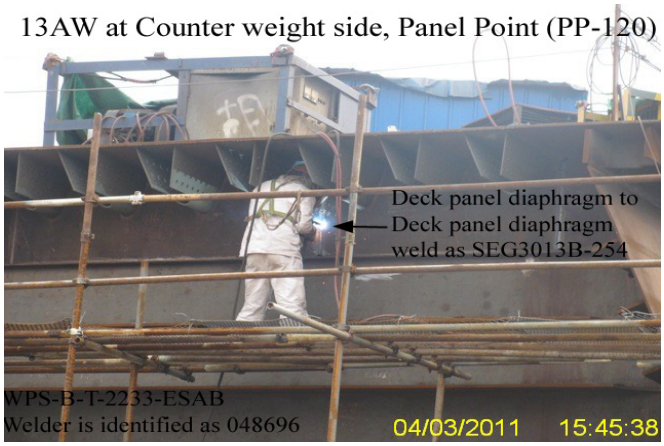
JIAN BO was onsite monitoring the welding variables. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2233-ESAB. Further weld detail mention in attached picture.

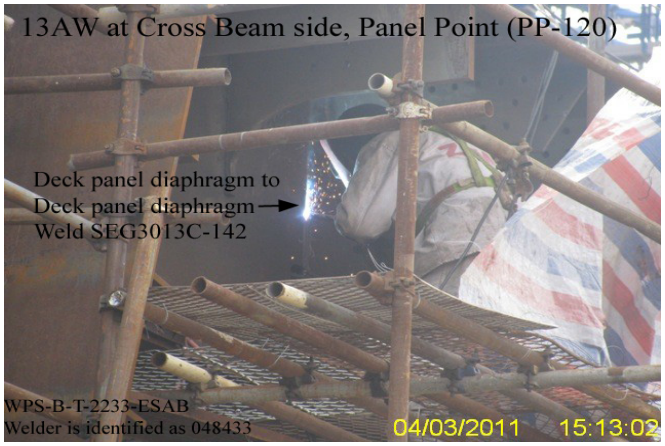
ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the floor beam to I-stiffener weld joint located on 13AW. The weld is designated as SEG3013S-189. The welder is identified as 067572. ZPMC QC Mr. SHEN JIAN BO was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2213-TC-U4b-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the edge plate to I-stiffener weld joint located on 13AW. The weld is designated as SEG3013L-067. The welder is identified as 067764. ZPMC QC Mr. SHEN JIAN BO was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2214- TC-U4b-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the floor beam to I-stiffener weld joint located on 13AW. The weld is designated as SEG3013R-191. The welder is identified as 067609. ZPMC QC Mr. SHEN JIAN BO was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2213-TC-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.





Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Pillai,Santosh Quality Assurance Inspector

WELDING INSPECTION REPORT

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Reviewed By: Miller,Mark QA Reviewer